

Date: Monday, 9/18/2006 2:30:32 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : PEDAL ASSEMBLY
 Job Number : 28642
 Estimate Number : 11005
 P.O. Number : N/A Part Number : D412704041
 This Issue : 9/18/2006 S.O. No. : N/A Drawing Number : IIN-D412-704 PG6,11
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : A
 Previous Run : 26150 Material : N/A
 Due Date : 9/30/2006 Qty: 4 Um: Each
 Written By : JA 06 09 18
 Checked & Approved By : JA 06 09 18
 Comment : Est Rev:B 05.04.28 Removed hardware on Step 2; Added
 Figures 1-3 KJ/RF
 Est Rev:C 06.03.08 Re-format EC

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
 Assemble pedal as per Dwg IIN-D412-704 and Figures 1-3
 Note: Only engage one thread on each bolt.

FF 06-10-12

4

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

3.0	D3204041	Pedal Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
✓ 1	D3204-041	Pedal Assembly	B23524

FF 06-10-12

4

4.0	D32051	Bracket
-----	--------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
✓ 1	D3205-1	Bracket	B25964

FF 06-10-12

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: PEDAL ASSEMBLY

Job Number: 28642

Part Number: D412704041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D32053

Back Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description batch

1 D3205-3 GHW Bracket

B26001

FF 06-10-12

4

6.0

D32061

Pedal Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description batch

1 D3206-1 Pedal arm

B26153

P70

FF 06-10-12

4

7.0

D3209041

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description batch

1 D3209-.041 Bracket

B23527

FF 06-10-12

4

8.0

AN310A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description batch

1 AN3-10A Bolt

NB17566

FF 06-10-12

4

9.0

AN3154R

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description batch

1 AN315-4R Nut

NB17566

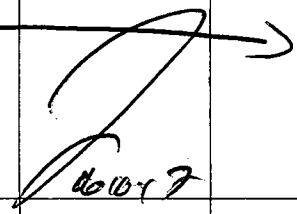
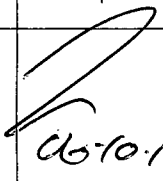
FF 06-10-12

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QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06.10.12	6.0	Part D3206-1 $\phi 0.191$ holes are out of tolerance $\phi 0.180$	PH per QSI 042	drill out holes to $\phi 0.191$ deburr and touch up \uparrow I.A.W D3206-1 Rev H.	PH per QSI 042			 06-10-12

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Drawing Name: PEDAL ASSEMBLY

Job Number: 28642

Part Number: D412704041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

AN410A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description batch
1 AN4-10A Bolt M 17073

FF 06-10-12

4

11.0

AN412A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part number Description batch
2 AN4-12A Bolt M 101390

FF 06-10-12

4

12.0

AN413A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description batch
1 AN4-13A Bolt M 101938

FF 06-10-12

4

13.0

AN960JD10

Washer



Comment: Qty.: 5.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part number Description batch
5 AN960JD10 Washer M 100743

FF 06-10-12

4

14.0

AN960JD416

Washer



Comment: Qty.: 11.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty Part number Description batch
11 AN960JD416 Washer M 19105

FF 06-10-12

4

15.0

AN960JD416L

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part number Description batch
3 AN960JD416L Washer M 101237

FF 06-10-12

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: PEDAL ASSEMBLY

Job Number: 28642

Part Number: D412704041

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

MS21042L3

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:



Qty	Part number	Description	batch
3	MS21042L3	Nut	M101390

FF 06-10-12

4

17.0

MS21042L4

Nut



Comment: Qty.: 5.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:



Qty	Part number	Description	batch
5	MS21042L4	Nut	M19099

FF 06-10-12

4

18.0

MS24694S102

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:



Qty	Part number	Description	batch
1	MS24694S102	Screw	M14604

FF 06-10-12

4

19.0

MS951910

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:



Qty	Part number	Description	batch
1	MS9519-10	Bolt	M100290

FF 06-10-12

4

20.0

AN960JD10L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:



Qty	Part number	Description	batch
4	AN960JD10L	Washer	M101291

FF 06-10-12

4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 06/10/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: PEDAL ASSEMBLY

Job Number: 28642

Part Number: D412704041

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

AN36A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part number Description
2 AN3-6A Bolt

batch

1118950

FF 06-10-12

22.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

Inspect work on ASS'y.

06-10-20 4

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57492

06-10-20 (4)

24.0

QC21

FINAL INSPECTION W/O RELEASE



Comment: FINAL INSPECTION W/O RELEASE

06-10-20 (4)

Job Completion



U 06-10-20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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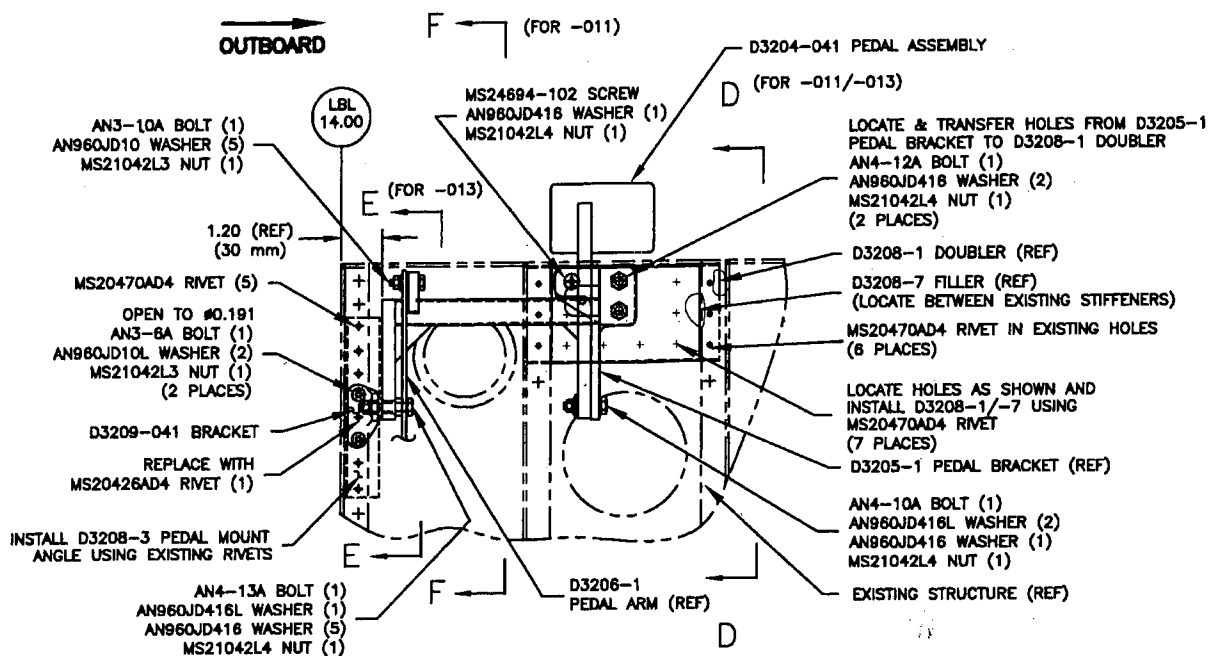


Figure 2 – Detail A. View looking AFT
(Co-pilot's Side -011/-013 Installations).

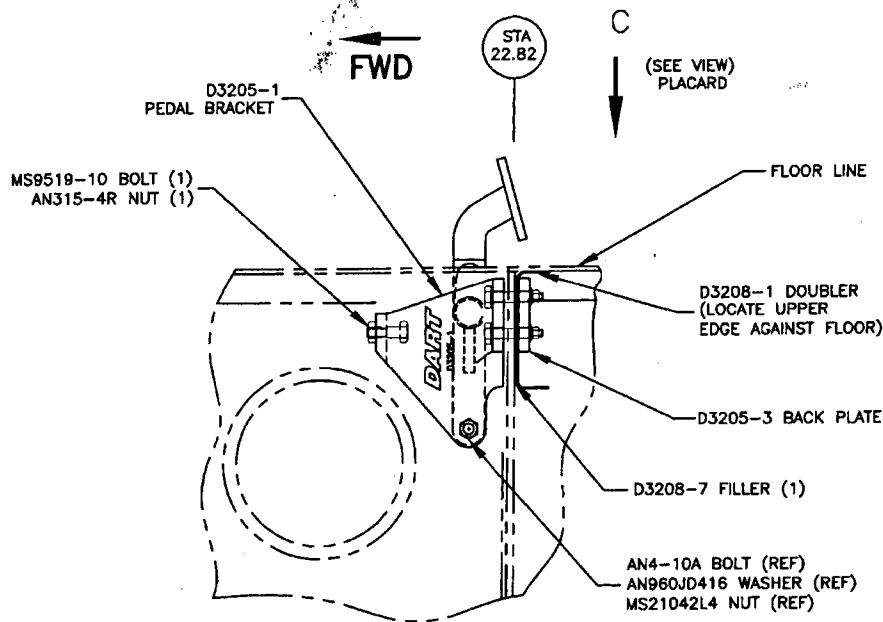


Figure 3 – View D-D. View looking Inboard
(-011/-013 Installations)

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Revision: A
Date: 04.02.03

5.0 PARTS LIST

Qty -011	Qty -013	Qty -041	Qty -043	Qty -045	Part Number	Description
X					D412-704-011	COPILLOT'S EMERGENCY CARGO RELEASE KIT (BELL 212/ 214 / 412)
	X				D205-704-013	COPILLOT'S EMERGENCY CARGO RELEASE KIT (BELL 205)
1	1	X			D412-704-041	PEDAL ASSEMBLY (205/ 212/ 214/ 412)
	1		X		D205-704-043	CABLE ASSEMBLY (205)
1				X	D412-704-045	CABLE ASSEMBLY (212/ 214/ 412)
		1			D3204-041	PEDAL ASSEMBLY (OR ECM 999702-1)
		1			D3205-1	PEDAL BRACKET (OR ECM 999703-1)
		1			D3205-3	BACK PLATE (OR ECM 999709-5)
		1			D3206-1	PEDAL ARM (OR ECM 999704-1)
	1				D3207-1	BRACKET
1					D3207-2	BRACKET
	1				D3207-3	BRACKET
1					D3207-5	BRACKET
1	1				D3208-1	DOUBLER (OR ECM 999709-1)
1					D3208-11	FILLER
1	1				D3208-3	PEDAL MOUNT ANGLE (OR ECM 999709-7)
	1				D3208-5	MOUNT ANGLE
1	1				D3208-7	FILLER (OR ECM 999709-3)
1					D3208-9	DOUBLER
		1			D3209-041	BRACKET ASSEMBLY (OR BHT 204-070-993-001)
1	1				D3214-1	PLACARD (OR ECM 999712-1)
			1		D3217-1	CABLE
				1	D3217-3	CABLE
			1	1	D3257-1	FITTING
			1	1	D3258-1	ANGLE BRACKET
		1			AN315-4R	NUT
		5	2	2	AN960JD10	WASHER
		4	2	2	AN960JD10L	WASHER
		11			AN960JD416	WASHER
		3			AN960JD416L	WASHER
			3	3	NAS509-3	NUT
		3	2	2	MS21042L3	NUT (OR MS21042-3)
		5			MS21042L4	NUT (OR MS21042-4)
4	4				MS21919DG5	CLAMP
		1			MS24694-S102	SCREW
	2				MS35489-10	GROMMET
			1	1	AN3-5A	BOLT
		2			AN3-6A	BOLT
		1			AN3-10A	BOLT
			1	1	AN3-13A	BOLT
		1			MS9519-10	BOLT
		1			AN4-10A	BOLT
		2			AN4-12A	BOLT
		1			AN4-13A	BOLT

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